

# Work Order ID 76373

November-11-11 8:11:38 AM

**\*76373\***

Page 1

Item ID: D2596

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web, 205 Skidtube.

Start Date: 11/11/2011 Start Qty: 6.00

**\*6\***

Cust ID:

Required Date: 11/11/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 11/11/11

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								

100-

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

*JW*

*11-11-11*

110

Chemical Conversion Coat per QSI005 4.1

0.00

**\*110\***

HandFinish

Memo

0.00

Hand Finishing

*JW*

*11-11-15*

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*DP*

*11-11-15*

*Co*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/21/11	1						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 76373****\*76373\***

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November-11-11 8:11:38 AM

Item ID: D2596 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Web, 205 Skidtube  
Start Date: 11/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 11/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <b>46</b>	0.00	<b>DP</b>	<b>11-11-15</b>				<b>⑥</b>	
<b>*130*</b>	Memo	0.00							
Packaging									
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							<b>11/11/16</b> <b>JD</b>
<b>*140*</b>	Memo	0.00							
QC									
Quality Control									<b>11-11-15</b> <b>⑥</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-11-11 8:11:42 AM

Page 1

Work Order ID: 76373

**\*76373\***

Parent Item: D2596

**\*D2596\***

Parent Item Name: Web, 205 Skidtube

Start Date: 11/11/2011

Required Date: 11/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM  
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	84.0000	1	6			
									**				

**\*D2500-3-100\***

Ext'n - 'I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

84

51957

2

66298

82

(6)

JW 11-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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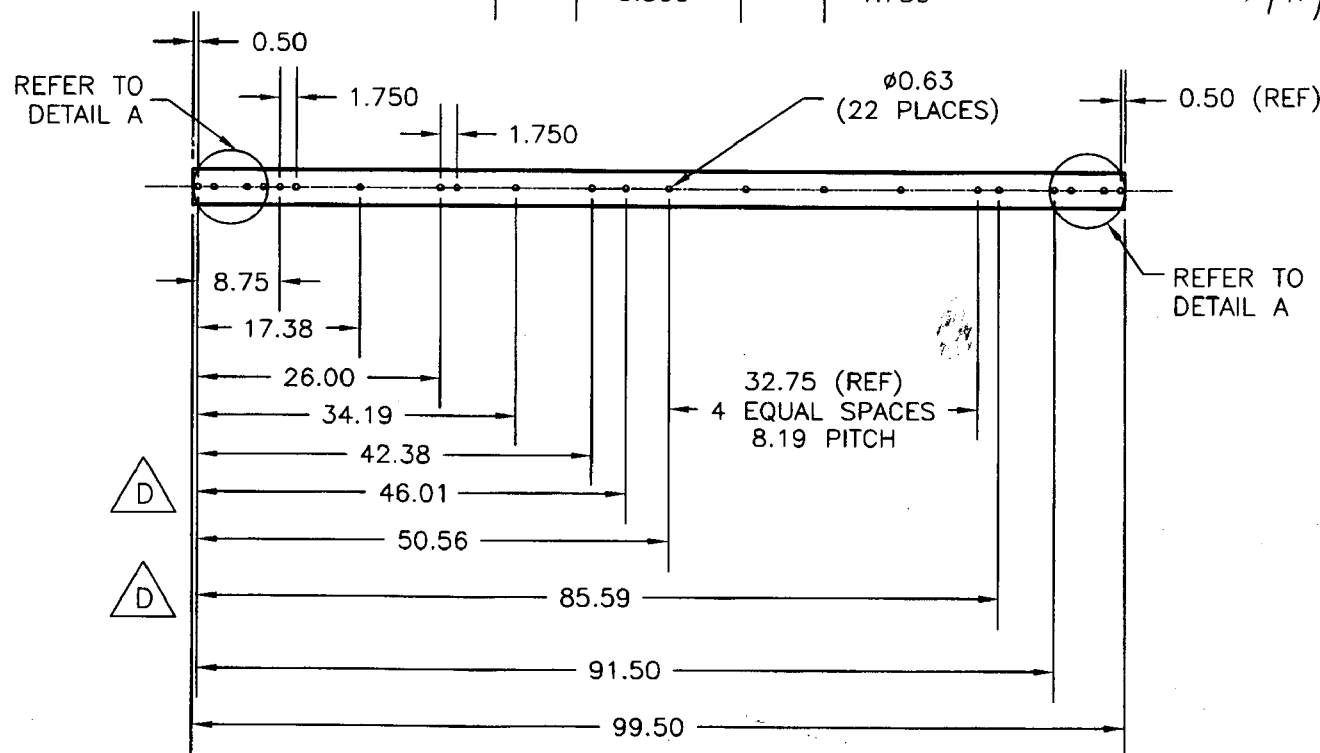
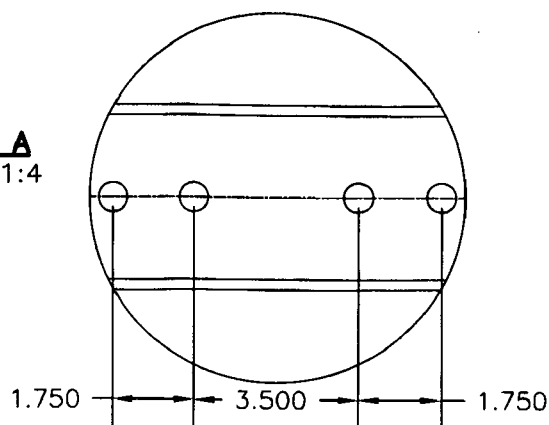
**NOTE:** Date & initial all entries

**DART**

**RELEASED**  
07 DEC 68

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76373 Y. 6.5  
11/11/11

**DETAIL A**  
SCALE 1:4



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	RA	DRAWN BY	AT	DART AEROSPACE LTD	REV. D
CHECKED	AT	APPROVED	AT	HAWKESBURY, ONTARIO, CANADA	
DATE	07.04.17	DRAWING NO.	D2596		SHEET 1 OF 1
		TITLE	205 WEB		SCALE
					1:20
A		96.09.16	NEW ISSUE		
B		97.07.23	Ø0.63 HOLE WAS Ø0.56		
C		98.09.14	INCORPORATED DEO 9097		
D		07.04.17	INCORPORATED DEO 9183		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & Initial all entries